

# Work Order ID 50320

July 14, 2009 12:01:52 PM



Page 1

Item ID: D2174-041

Accept



Setup Start



Revision ID: E

Stop



Item Name: Web, 205

Start Date: 7/15/09

Start Qty: 10.00 10



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2174

Rev E

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Assemble as per Dwg D2174-041 2- Identify as D2174-041

*09/07/27 (10)*

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*=> 501467*

*(10) 8*

120

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

*1:00*

OVEN TEMPERATURE:

*320°* FINISH TIME:

*1:30*

*09/07-27 (10)*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 50320

July 14, 2009 12:01:52 PM

Page 2

Item ID: D2174-041

Accept

Revision ID: E

Item Name: Web, 205

Start Date: 7/15/09 Start Qty: 10.00

Required Date: 7/15/09 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:




SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							
140  Small Fab Small Fab	Small Fab  Memo Install nuts & bolts loosely as per Dwg D2274	0.00  0.00							
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							

09-07-28

(10)

W

09/07/28 (10)

=> 8/9/07/28

(10)

f

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 50320

July 14, 2009 12:01:52 PM



Page 3

Item ID: D2174-041

Accept



Setup Start



Revision ID: E

Stop



Item Name: Web, 205

Start Date: 7/15/09 Start Qty: 10.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Identify as per dwg & Stock Location: 199

0.00



Packaging

Memo

0.00

Packaging

9-7-28 (Lbx) Sq

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

28-07-00

09/07/29

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

July 14, 2009 12:01:51 PM

Work Order ID: 50320



Parent Item: D2174-041RevE



Parent Item Name: Web, 205

Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN526C832R14 Purchased

No

140

Each

1,033.000

40.0000



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1033

104916

1033

AN960JD8

Purchased

No

140

Each

953.0000

40.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

953

107091

9

108335

11

110382

48

110917

3

111578

882

D2174-1RevE

Manufactured

No

100

Each

0.0000

10.0000



Web

650234

EP 09/07/27

✓

EP 09/07/27

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

✓

EP 09/07/27

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

July 14, 2009 12:01:51 PM

Work Order ID: 50320

Parent Item: D2174-041RevE

Parent Item Name: Web, 205

Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2175-1RevE		Manufactured	No			100	Each	2.0000	10.0000			
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Angle LH

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse

ST	2	
----	---	--

31691	2	
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D2175-2RevE		Manufactured	No			100	Each	1.0000	10.0000			
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Angle RH

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse

ST	1	
----	---	--

48413	1	
-------	---	--

MS20470AD4-6		Purchased	No			140	Each	1,785.000	190.0000			
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Rivet, Universal Head

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse

ST	1785	
----	------	--

109371	64	
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110915	1721	
--------	------	--

*CP 09/07/27*  
*B 50326*

*CP 09/07/27*  
*B 50230*

*CP 09/07/27*  
*✓*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

July 14, 2009 12:01:51 PM

Work Order ID: 50320



Parent Item: D2174-041RevE



Parent Item Name: Web, 205

Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L08

Purchased

No

100

Each

138.0000

40.0000



Nut

*07/07/27*

*†*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

138

110002

24

111889

114

*M112243*

*✓*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

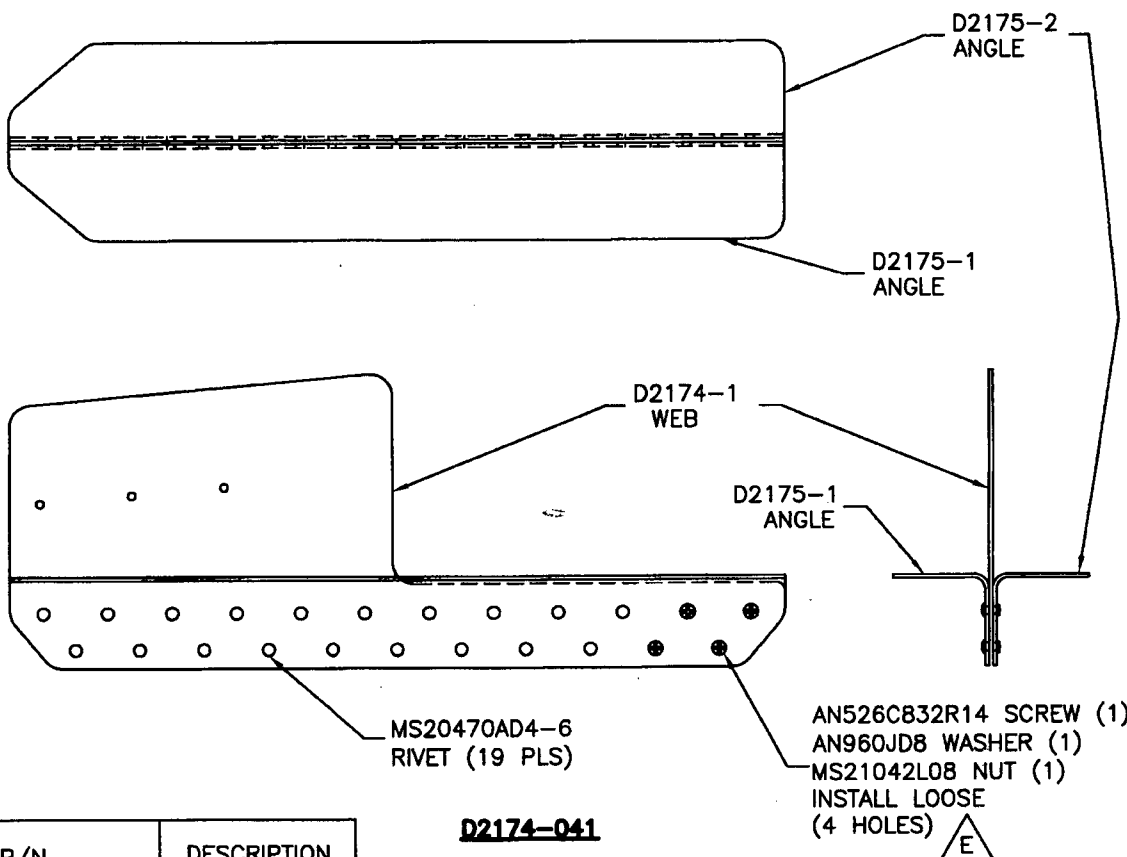
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN	RF	DRAWN BY	CE	DART AEROSPACE LTD
CHECKED	PH	APPROVED	CH	HAWKESBURY, ONTARIO, CANADA
DATE	06.09.25	TITLE	D2174	REV. E
		WEB ASSEMBLY		SHEET 1 OF 2
A	95.10.25	NEW ISSUE		SCALE
B	96.01.18	RE-DRAWN		1:3
C	00.09.11	UPDATE FINISH SPEC.		
D	04.06.03	RE-DESIGN		
E	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE		

**D2174-041**

QTY	P/N	DESCRIPTION
-041		
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

**NOTES:**

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

**RELEASED**  
06.10.13

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

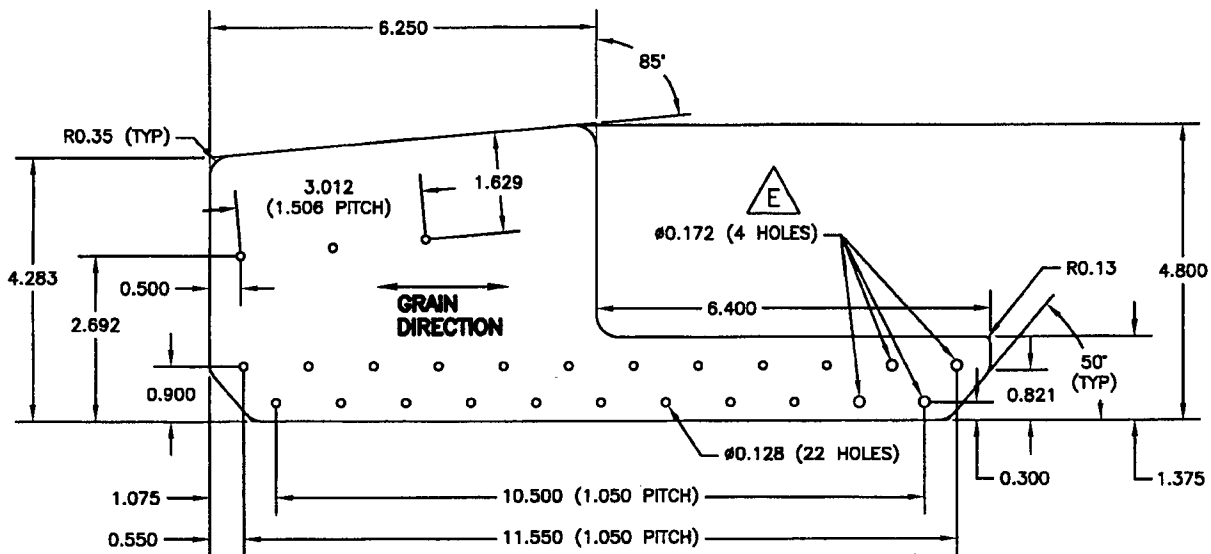
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	RF	DRAWN BY	CE	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	06.09.25	DRAWING NO.	D2174	REV. E
		TITLE	WEB	SHEET 2 OF 2
		SCALE	1:3	



**D2174-1**

**NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSION ARE IN INCHES

50320

**RELEASED**

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries